

G6410277

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



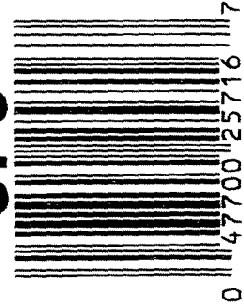
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410277

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



SERIAL NO.



10/26/2004 7:51:17 AM

Ctrl

01

Original

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)



.MA25716

Shop Order: SWS10-15-5



.ABSWS10-15-5

Start Date: 9/20/2004

Finish Date: 10/15/2004

0540

01PC001

Flat Black Powder Coat. Barrel and



0003512703

0560

89SWS1

Reassemble Action.



0003512704

0690

89SWS1

Pack Rifle



0003512697

0700

89SWS1

Stencil SWS Container



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410277

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTZ
600	PROOF		8-24-04	RTZ
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-04	RTZ
610	DIS-ASSEMBLE GUN	AUG 25 2004	8-24-04	RTZ
612	MAGNAFLUX BBL ACTION, MAGNAFLUX BOLT	OPERATOR <u>[Signature]</u>		
615	ROLLMARK CALIBER		8/25/04	JB
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRW
620	APPLY COATINGS (BARREL ACTION)		9/7	TRW
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-04	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-04	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-04	RTZ
	D) OIL FIRING PIN ASSEMBLY		10-5-04	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>6.0</u>	10/7/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>3.0</u>	10/7/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	10/7/04	DA
	J) ASSEMBLE STOCK		10-5-04	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-12-04	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-5-04	RTZ
	M) IRON SIGHT ALIGNMENT		10-5-04	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-5-04	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	10-7-04	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
645	INSPECT FOR LIVE AMMO		10-7-04	TRW
655	FINAL INSPECTION A) HEADSPACE		10-12-04	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.75</u> <u>2.64</u> <u>2.89</u> <u>2.85</u>	10/7/04	DA
	C) FUNCTION		10-12-04	RTZ
660	PACK		10/25/04	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

SERIAL NO.

DATE

9-29-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.24	2.08		2.11	
PULL #2	2.36	2.15		2.03	
PULL #3	2.20	2.12		2.22	
PULL #4	2.19	2.20		2.10	
PULL #5	2.10	2.23		2.08	
TOTAL	11.09	10.78		10.54	
AVERAGE	2.21	2.15		2.10	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	2.95		
PULL #2	3.25	3.03		
PULL #3	3.11	3.02		
PULL #4	3.02	2.99		
PULL #5	3.09	3.02		
TOTAL	15.57	15.01		
AVERAGE	3.11	3.00		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.23	3.93		4.35
PULL #2	4.27	4.01		4.36
PULL #3	4.24	3.99		4.34
PULL #4	4.21	4.34		4.39
PULL #5	4.11	4.10		4.36
TOTAL	21.06	20.37		21.80
AVERAGE	4.21	4.07		4.36

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410277.__0
FILE DATE AND TIME: 10/07/2004 06:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.025
The Average Y Centroid of the Five Target Set:	-0.201
The Average Point of Impact of the Five Target Set:	0.202
The Average Mean Radius of the Five Target Set:	0.732
The Distance from POA to Centroid Target #1:	0.221
The Distance from Centroid Target #2 to Centroid Target #1:	0.176
The Distance from Centroid Target #3 to Centroid Target #1:	0.232
The Distance from Centroid Target #4 to Centroid Target #1:	0.165
The Distance from Centroid Target #5 to Centroid Target #1:	0.120

SERIAL NUMBER: G6410277. 0

TARGET NUMBER: 1

FILE DATE: 10/07/2004

FILE TIME: 06:31

X CENTROID: -0.128

Y CENTROID: -0.180

POA TO CENTROID: 0.221

HORZ SPREAD: 1.308

VERT SPREAD: 2.344

GROUP SPREAD: 2.461

MIN RADIUS: 0.220

MAX RADIUS: 1.292

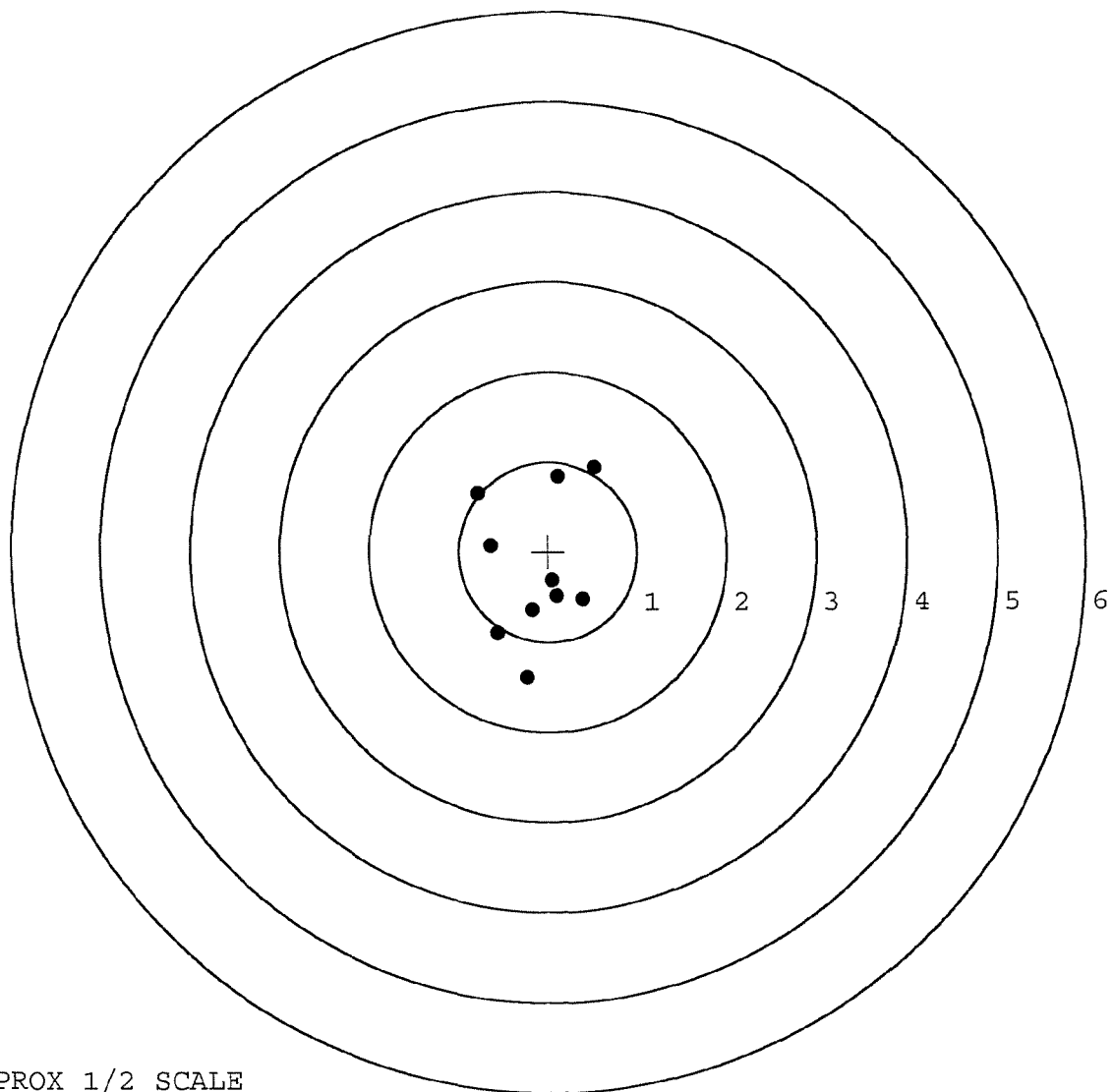
MEAN RADIUS: 0.776

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.515	0.940
2:	0.112	0.839
3:	-0.793	0.652
4:	-0.645	0.068
5:	0.041	-0.322
6:	0.389	-0.525
7:	-0.183	-0.648
8:	0.098	-0.499
9:	-0.236	-1.404
10:	-0.574	-0.906



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410277. 0

TARGET NUMBER: 2

FILE DATE: 10/07/2004

FILE TIME: 06:31

X CENTROID: 0.007

Y CENTROID: -0.067

POA TO CENTROID: 0.067

HORZ SPREAD: 1.734

VERT SPREAD: 2.025

GROUP SPREAD: 2.056

MIN RADIUS: 0.293

MAX RADIUS: 1.289

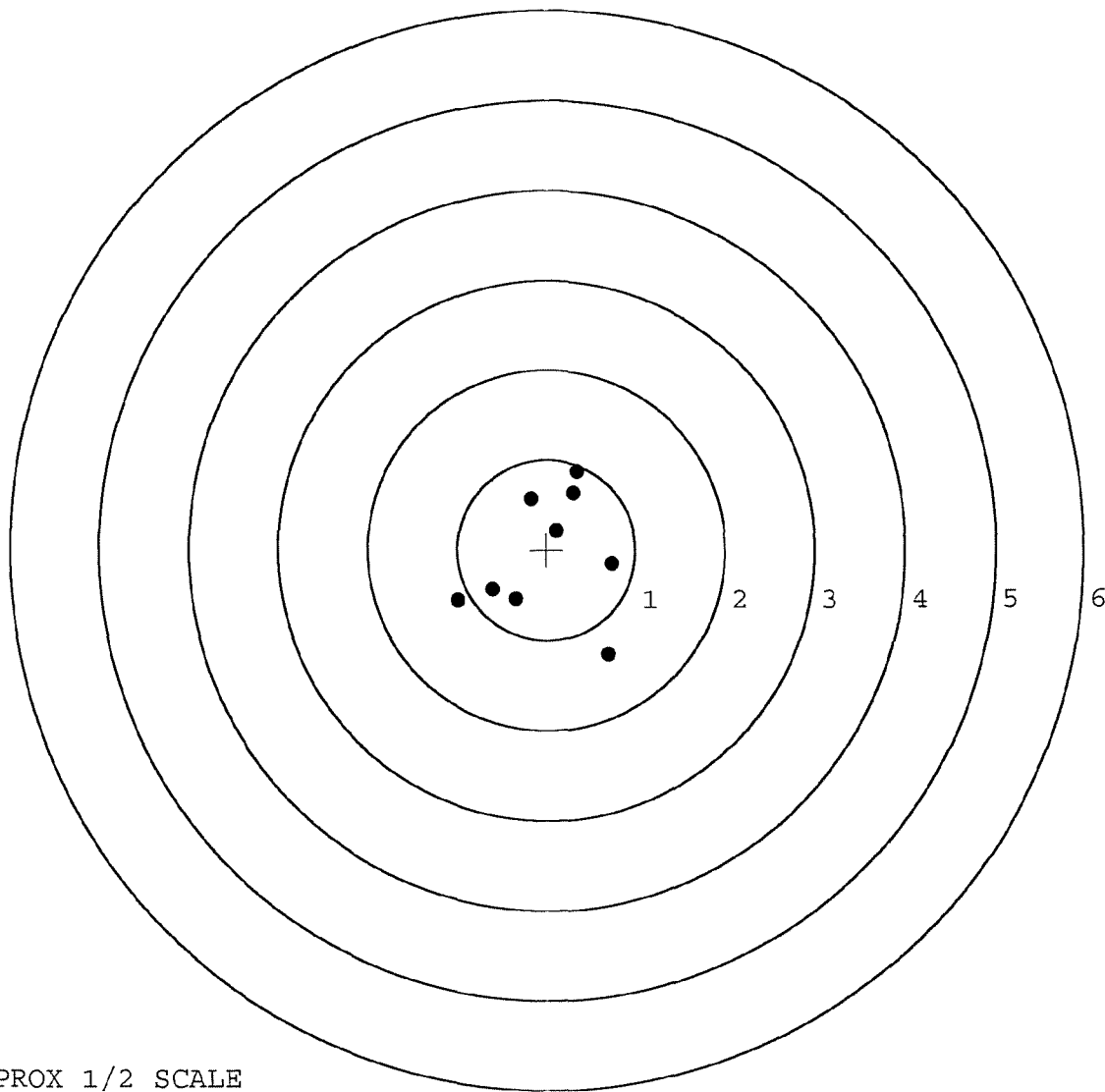
MEAN RADIUS: 0.797

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.698	-1.155
2:	0.737	-0.155
3:	-0.349	-0.551
4:	-0.612	-0.445
5:	-0.997	-0.567
6:	0.111	0.207
7:	0.305	0.633
8:	0.342	0.870
9:	-0.175	0.563



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410277. 0

TARGET NUMBER: 3

FILE DATE: 10/07/2004

FILE TIME: 06:31

X CENTROID: 0.105

Y CENTROID: -0.173

POA TO CENTROID: 0.202

HORZ SPREAD: 1.326

VERT SPREAD: 2.422

GROUP SPREAD: 2.439

MIN RADIUS: 0.206

MAX RADIUS: 1.344

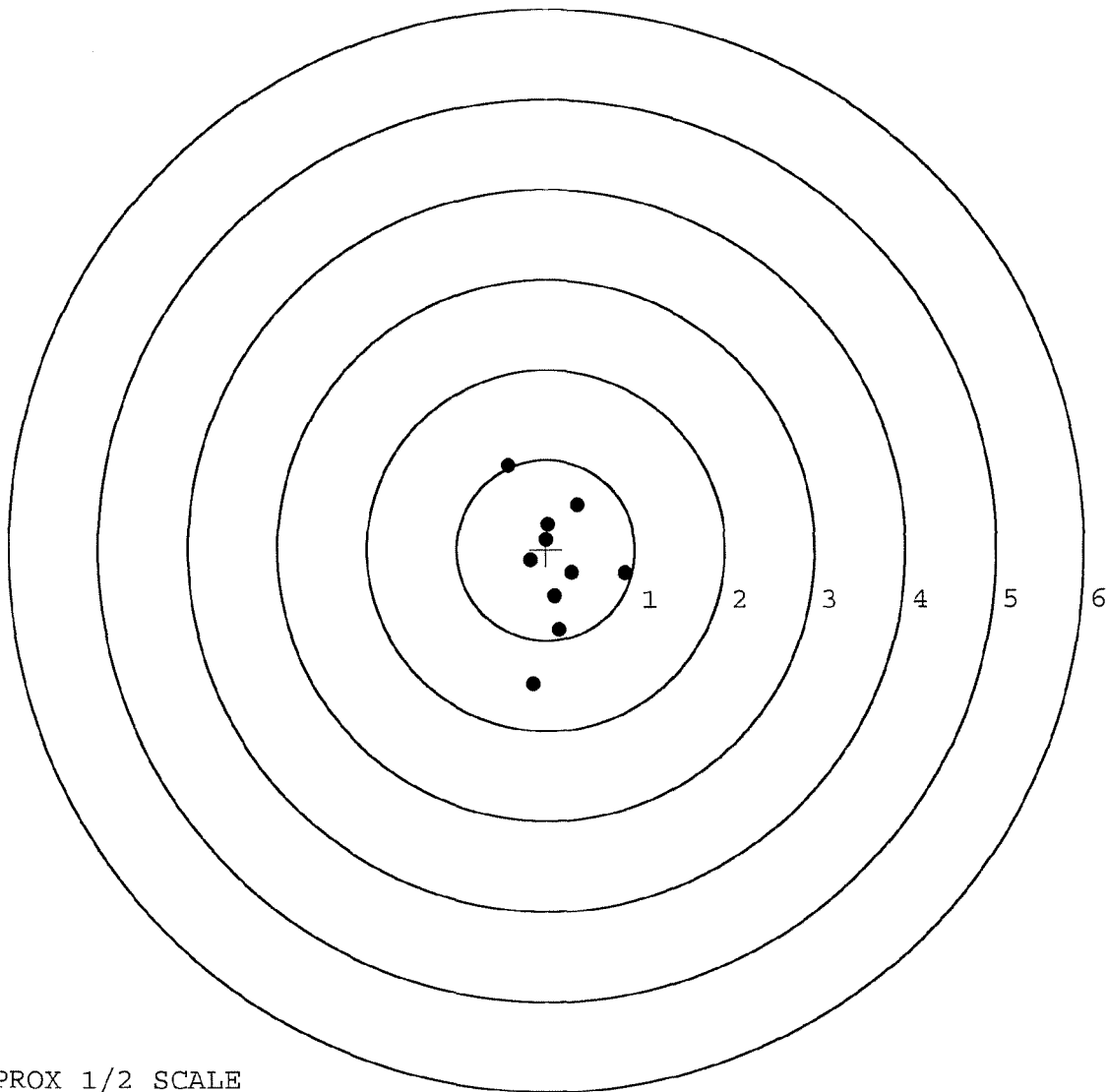
MEAN RADIUS: 0.639

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.149	-1.492
2:	0.142	-0.892
3:	0.893	-0.262
4:	0.293	-0.256
5:	0.096	-0.518
6:	0.353	0.495
7:	0.025	0.280
8:	0.002	0.109
9:	-0.175	-0.120
10:	-0.433	0.930



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410277. 0

TARGET NUMBER: 4

FILE DATE: 10/07/2004

FILE TIME: 06:31

X CENTROID: -0.001

Y CENTROID: -0.286

POA TO CENTROID: 0.286

HORZ SPREAD: 1.945

VERT SPREAD: 1.497

GROUP SPREAD: 2.032

MIN RADIUS: 0.298

MAX RADIUS: 1.057

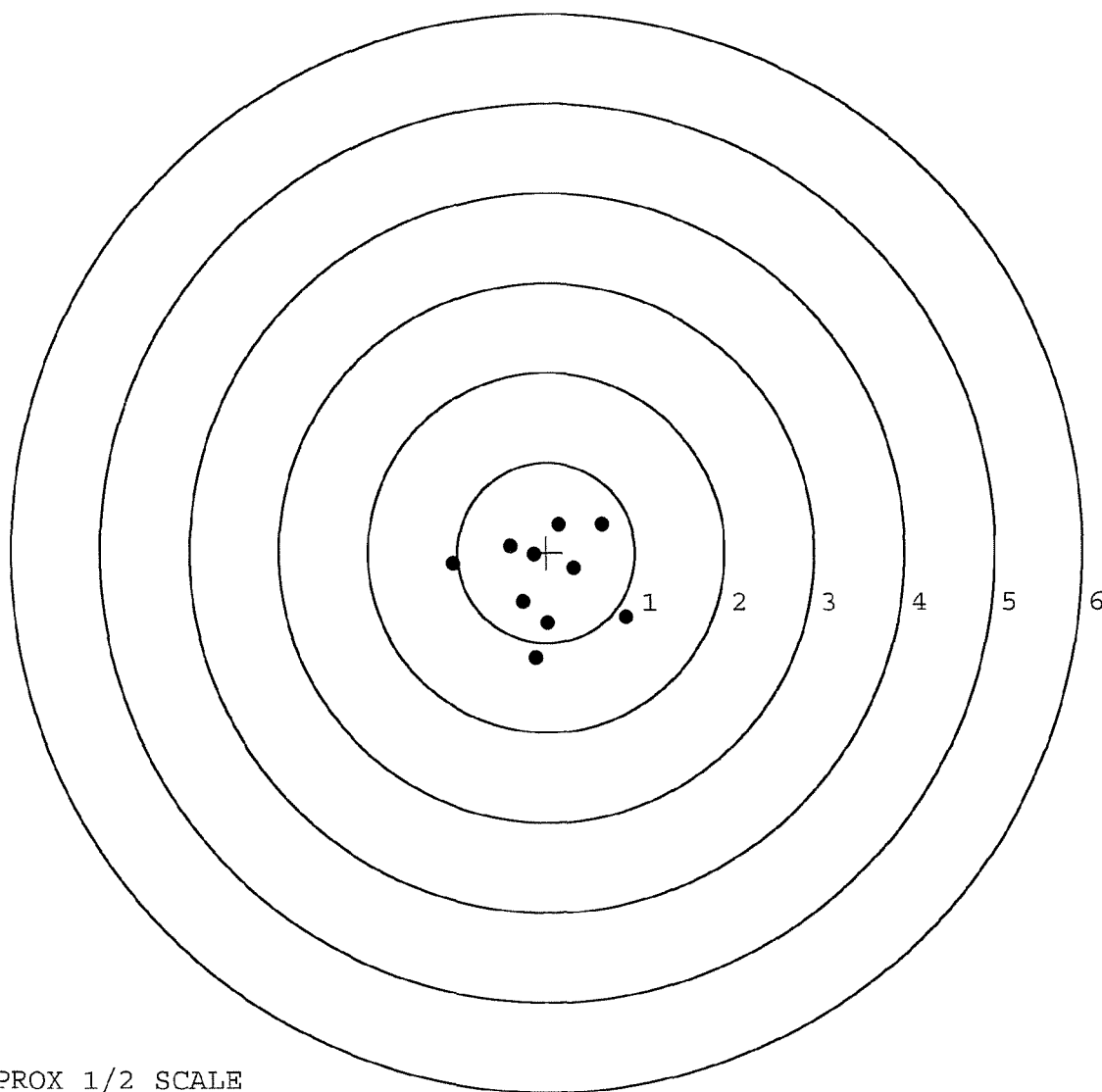
MEAN RADIUS: 0.649

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.898	-0.719
2:	-0.120	-1.180
3:	0.010	-0.785
4:	-0.272	-0.551
5:	-1.047	-0.131
6:	0.626	0.317
7:	0.311	-0.173
8:	0.134	0.312
9:	-0.141	-0.023
10:	-0.409	0.070



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410277. __0

TARGET NUMBER: 5

FILE DATE: 10/07/2004

FILE TIME: 06:31

X CENTROID: -0.105

Y CENTROID: -0.298

POA TO CENTROID: 0.316

HORZ SPREAD: 1.540

VERT SPREAD: 1.884

GROUP SPREAD: 2.321

MIN RADIUS: 0.364

MAX RADIUS: 1.178

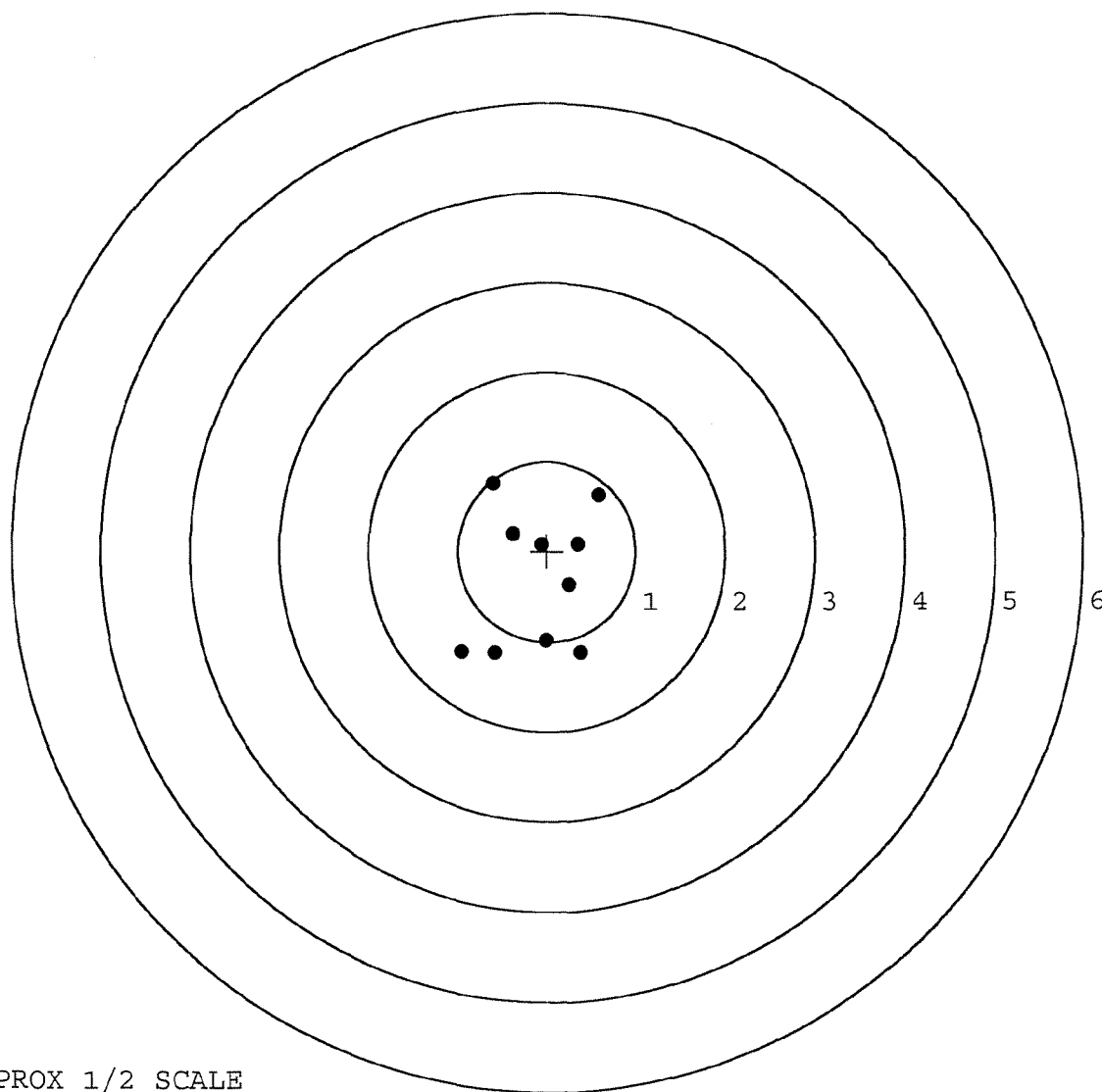
MEAN RADIUS: 0.801

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.383	-1.118
2:	-0.014	-0.992
3:	-0.589	-1.125
4:	-0.959	-1.110
5:	0.581	0.627
6:	-0.607	0.759
7:	0.352	0.085
8:	0.252	-0.367
9:	-0.063	0.068
10:	-0.391	0.190



TARGET APPROX 1/2 SCALE